ASPY

### \*77761\*

Page 1

Item ID: Revision ID: Item Name:	D350-591-312 Heli-Access-Step, Long	RH		Accept	*N900	<b>040</b>	100	)*	Setup Star Stop	1/1	S1*
	21/12/2011 Start (	Qty: 4.00 Qty: 4.00	*4* *4*		Cust Item I Customer:	D:				I	.7/
Approvals:	Process Plan:M_			•		ite:		]	Run Star Stop	1/1	R1* R2*
Sequence ID/ Work Center II	Operat Descrip			Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nb	r				<del></del>	J				4.
D3272	Rev B		•					1			
*100*	DOCUM	ENT CONTRO	OL <b>18</b>	0.00					12		05 A
DC		Memo		0.00							
Document Control		Photocopy	bluefile and type labe	ls as per PPP D350-591-312 C Non Euroco	New 602						A STATE OF THE STA
*110  *110*  Large Fab  Large Fab	Large Fal	Memo	d for welding FWD ON	0.00		V 11 · 12 · 6	2		<i>\$</i>		·
		D3272 A/R Alu	pport using Jig DT871 minum Rod <u>M//45</u> M//87 id Plate flush	9, weld Fwd End Plate as per Q	2SI 004 & Dwg						

	Dar	t A	ero	sp	ace	e Lt	d
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W/O:			• <b>V</b>	VORK ORDER CHAN	GES					T
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Work Order ID 77761  December-21-11 9:03:15 AM			. ` ` `	*777	761*						Page 2
Item ID: Revision ID:	D350-591-3	12		Accept	*N900	040	100	<b>)*</b> s	Setup Sta	i	S1*
Item Name:	Heli-Access-S	Step, Long RH							Sto	<sup>p</sup> *N	S2*
Start Date: Required Date:	21/12/2011 29/12/2011	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:					
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	QC:		Date:	SPC (Y/N):	Da	ate:			Sto	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		QC9- Inspect visual per	QSI004- Fusion Welds	0.00				06	01	_	•
*120* QC Quality Control		Memo		0.00				4	Ø.	BELL	-12-26
							-				
130		QC5- Inspect part compl	eteness to step on W/O	0.00							
*130* QC Quality Control		Memo		0.00 S 41	17/13			RY			

140

Chemical Conversion Coat per QSI005 4.1

0.00

Le 11.12.28

\*140\* HandFinish

Memo

0.00

Hand Finishing

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Page 3

Reject

Number

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December-21-11 9:03:15 AM D350-591-312 Item ID: Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Heli-Access-Step, Long RH **Start Date:** 21/12/2011 Start Otv: 4.00 **Cust Item ID:** Req'd Qty: 4.00 **Required Date: 29/12/2011 Customer:** Reference: Run Start Process Plan: **Approvals:** Date: Tooling: Date: Stop Date:\_\_ QC: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject **Work Center ID** Description Qty Qty **Run Hours** Code 150 QC3- Inspect Part Finish 0.00 \*150\* 0.00 Memo Quality Control 180 0.00 M12.01.02 Large Fab \*120\* Large Fab 0.00 Memo Large Fab 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/RAluminum Rod M114514 6-Grind End Plate flush 7-Install last rivet as per Dwg.

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	0.2.	Section A	Chief Eng	Chief Eng	Date	Section C	Chief Eng	QC Inspector		
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Work Orde				*777	761*							Page 4
Item ID: Revision ID:	D350-591-31			Accept	*N900	<b>040</b>	100	)*	Setup	Start Stop	ı Vı,	S1*
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Approvals:		ın:				ate:			Run	Start Stop	1/1	R1* R2*
Sequence ID/ Work Center II  190 *100* QC Quality Control	)	Operation Description QC10- Inspect visual per	QS1004- ground welds	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept	t Rej Qty		Reject Number	Insp. Stamp
200 *200* QC Quality Control		QC5- Inspect part compl	eteness to step on W/O	0.00	<b>3</b> 0Z			(R)	<u> </u>			
210 *210* HandFinish Hand Finishing		Chemical Conversion Co	oat per QSI005 4.1	0.00			4	łΧ <i>Ĵ</i>	M	1-L	/12	101/06

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Item ID: Revision ID: Item Name:	D350-591-3 Heli-Access-S			Accept	*N900	040	100	)* s	Setup Star	1.7	S1* S2*
Start Date: Required Date: Reference:	21/12/2011 : 29/12/2011	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item 3 Customer:						
Approvals:		nn:		_ 0 _		ate:		F	tun Start Stop		R1* R2*
Sequence ID/ Work Center II 220 *220 *220* Powdercoat Powder Coating		Operation Description White Gloss(Ref:4.3.5.1  Memo START TIM OVEN TEM FINISH TIM		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*230 *230* HandFinish Hand Finishing		Wing Walk as per dwg (  Memo	QSI005 4.4 Batch_ <i>   90</i>	94. 0.00 0.00			,	4 )	4 12	-1-3	3
240 * <b>?40</b> * QC Quality Control		QC3- Inspect Part Finish  Memo	1	0.00		Cou	nuted	4RH 2 ide	oti Ged	Щ.	2/01/0>

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Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		te:		-		Start Stop	*N  *N	R1* R2*
Sequence ID/ Work Center II 250 *250* Packaging	<b>D</b>	Operation Description Pick Kit Memo	. '	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
260 *260* QC Quality Control		QC4- 100% Inspect kits  Memo	for completeness	0.00	·			M	12	Ω	01	05 (1

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Packaging

Packaging

Packaging

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Identify and pack for shipping as per PPPD350-591-312 Loc 81
Location:\_\_\_\_\_

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Quality Control

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**Picklist Print** Page 1 December-21-11 9:03:18 AM Work Order ID: 77761 \*77761\* D350-591-312 Parent Item: \*D350-591-312\* Parent Item Name: Heli-Access-Step, Long RH Start Date: 21/12/2011 Required Date: 29/12/2011 Required Qty: 4.00 Start Qty: 4.00 IPP Rev:A04.03.22New issue KJ/RF Comments: IPP Rev:B 07-06-09 Added D3572-1 JLM DD verified by:EC IPP Rev:C 08-04-02 ECN1163 IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D fixe route seg in bom DD 10.04.28 verified by:EC Component Item ID/ Unit of Qty per Kit Total Replacement Mfg/ Bin Primary Last Route Qty on Qty Date Status Item Name Item Location Location Hand Seq ID Measure Item ID Purch Qty Issued Issued DSI 9410-011 Manufactured No Each 0.0000 \*\* \*DSI 9410-011\* Step Modification B #1359 D3272-1 Manufactured Each 0.0000 \*D3272-1\* \*\* Step Location Loc Qty Loc Code ST -10 WA 10 D3067-1 110 Each 67.0000 No Manufactured \*\* \*D3067-1\* End Plate Loc Code Location Loc Qty WA016 67 67582 2 68214 76179 64 D3219-1 110 Each 46.0000 2 Manufactured \*\* \*D3219-1\* Location Loc Qty Loc Code WA016 46

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Work Order ID: 77761		*77761*			4
Parent Item: D350-591-312 Parent Item Name: Heli-Access-St	tep, Long RH	*D350-59	1-312*	<b>Start Date:</b> 21/12/20 <b>Start Qty:</b> 4.00	Required Date: 29/12/2011 Required Qty: 4.00
D3066-1	Manufactured	No	180 Each	86.0000 2 8	12
*D3066-1*				**	1211-12-29
		Location WA015	<u>Loc Qty</u> 86	Loc Code	
NG20400 ABABA		76180	86	<u> </u>	3
MS20600-AD4W4	Purchased	No	180 Each	2,866.000 16 64	
*MS20600-AD4	VV4*			**	1811-12-29
		<b>Location</b>	Loc Oty	Loc Code	
		ST321	2861	<del></del>	<del></del>
		116183 11736			<del></del>
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		<u>11986</u> 11988			
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		WA018 116712	5		
D3065-041	Manufactured	No	180 Each	2.0000 1 4	
*D3065-041* Step Leg Assembly Hi				**	PE11.12.29
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*D3067-1* End Plate				٠. لو			**	- St.	11.12.29
			<b>Location</b>	Loc	c Oty	Loc Code			
			WA016		67				_
			67582		2				_
			68214 76179		1 64			4	_
AN3-35A	Purchased	No		250	Each	103.0000	2		_
*AN3-35A*							**	<del>_</del>	
			<b>Location</b>	Loc	c Qty	Loc Code		100	
			ST353		103				_
			119449		100			<u>2</u>	<del>_</del> .
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*D3235-1*	Manufactured	No		250	Each	107.0000	2 **	*_()_	
Mounting Lug				_					
			Location	Loc	e Oty	Loc Code			
			ST481 73411		107 . 7		•	7	
			75547		100		•	<b>W</b> 1	
D3278-041	Manufactured	No		250	Each,	42.0000	1'	4, 1	
*D3278-041*							**	istila	$\mathcal{L}(\mathcal{A})$
Support Assembly	•			*				10 (1 (-4	X / N
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	Work Order ID: 77761	<u> </u>	*77	761*		<u></u>					6
	Parent Item: D350-591-312 Parent Item Name: Heli-Access-Step, L	ong RH		50-591-3	12*				21/12/2011	Required Date: 29/12/2	
l Lx1	AN960JD416 NAS1149D0463J	Purchased	No		250	Each	0.0000	tart Qty: 4	64	Required Qty: 4.00	
	*AN960.1D416* Washer 7 AN960JD516 NAS1149D0563J	Purchased	No		250	Each	0.0000	<b>**</b>	16	4119075\$	
r N	*AN960.ID516*	-						**	milsa	106	
4	*AN5-36A* Bolt	Purchased	No		250	Each	105.0000	2 **	- \$		
1				<b>Location</b> ST340 119449 119641	<u>L</u>	105 30	Loc Code			- -	
'. ı	D2618 *D2618* Bushing	Manufactured	No	119041	250	75 Each	112.0000	2 **	<b>S</b>		
1				<b>Location</b> ST019 <u>74458</u> 76130	<u>L</u> (	112 12 100	Loc Code		8	- -	
4	*D2230 <sup>1</sup> 3 *D2230-3* <sub>Lug</sub>	Manufactured	No	70130	250	Each	212.0000	4 **	12/16	1 d) (4)	
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Parent Item Name: Heli-Access-Sto	ep, Long RH		JANU-NY I-:	71/	Start Date Start Qt	21/12/2011	Required Date: 29/12/2011 Required Qty: 4.00
D2856-400 *D2856-400* Abraison Strip	Manufactured	No		250 f	200.2721 1 **	2 48	
√ rcũ (2) D2856-400-720 as per dwg			Location ST409 63735 68076 71164 73491	Loc Oty 200.2721 0.6696 0.3149 21.66 177.6276	<u>Loc Code</u>	4.8	- - - -
MS21042L3 \ *MS21042L3 \ Nut	Purchased	No		250 Each	6,882.000		
/ AN4-13A			Location ST300  117441 117885 118451 118927 119017 119075	Loc Oty 6882 16 32 5 3 5988 838	Loc Code	5	- - - - -
/ *AN4-13A*	Purchased	No		250 Each	742,0000 <b>**</b>	12/1	pyst 4
			Location ST357 118078 118838 119449 119798	Loc Oty 742 17 125 500 100	Loc Code	2	- - - 

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W/O:			W	ORK ORDER CHANG	ES					, ,
DATE	STEP	PRO	OCEDURE CHA	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									r rod wgr	
	!									
Part No		PAR #:	Fault Cate	egory:	_ NCR	: Yes I	No DQA	•	Date:	
	R	esolution:	Disposition	on:	QA:	N/C Clo	sed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE	(NCR	)			
		Description of NC			ion B		Verifica	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Sectio		Chief Eng	QC Inspector
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										<u>.</u>
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Picklist Print December-21-11 9:03:19 AM							Page 6
Work Order ID: 77761		*77	761*				0
Parent Item: D350-591-312 Parent Item Name: Heli-Access-Step	o, Long RH		350-591-	312*		tart Date: 21/12/2011	Required Date: 29/12/2011
MS21042L5 *MS21042I 5*	Purchased	No		250 Each		Start Qty: 4.00	Required Qty: 4.00
/ MS21042L4 Y *MS21042I 4*	Purchased	No	Location ST300 116105 116548 117611 118179 118910 119109	Loc Oty  2130  5  43  52  496  34  1500  250  Each	<u>Loc Code</u> 9,089.000	** * * * * * * * * * * * * * * * * * *	
Nut			Location ST300 117441 117601 118451 119017 119075	Loc Oty 9089 51 342 133 3563 5000	<u>Loc Code</u>	32	
AN960JD10 NAS1149D036 *AN960.ID10*	Purchased	No		250 Each	0.0000	** 16 mil95	- 37 politu S/1

W/O:			W	ORK ORDER CHANG	ES			
DATE	STEP	PR	OCEDURE CHA	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			•					
Part No		PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQA:	Date: _	· · · · · · · · · · · · · · · · · · ·
	Re	solution:	Disposition	on:	_ QA: N/C Cld	sed:	Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR	)		
DATE	STEP	Description of NC		Corrective Action Section		Verification		Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description  Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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DESIG	a	DRAWN BY	DART AEROSPACE		•
	7	1	HAWKESBURY, ONTARIO, CANADA	<b>\</b>	•
CHEC	SED	APPROVED	DRAWING NO.		REV. B
	E	1	D3272	SHEET	1 OF 3
DATE			TITLE		SCALE
07.0	5.18		STEP ASSEMBLY, HI LONG		NTS
Α		04.03.01	NEW ISSUE		
В		07.05.18	D3272-1 WAS D2622-120		

OT OF ONE

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	Х	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
`L	l		
16	16	MS20600AD4W4	RIVET

#### GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

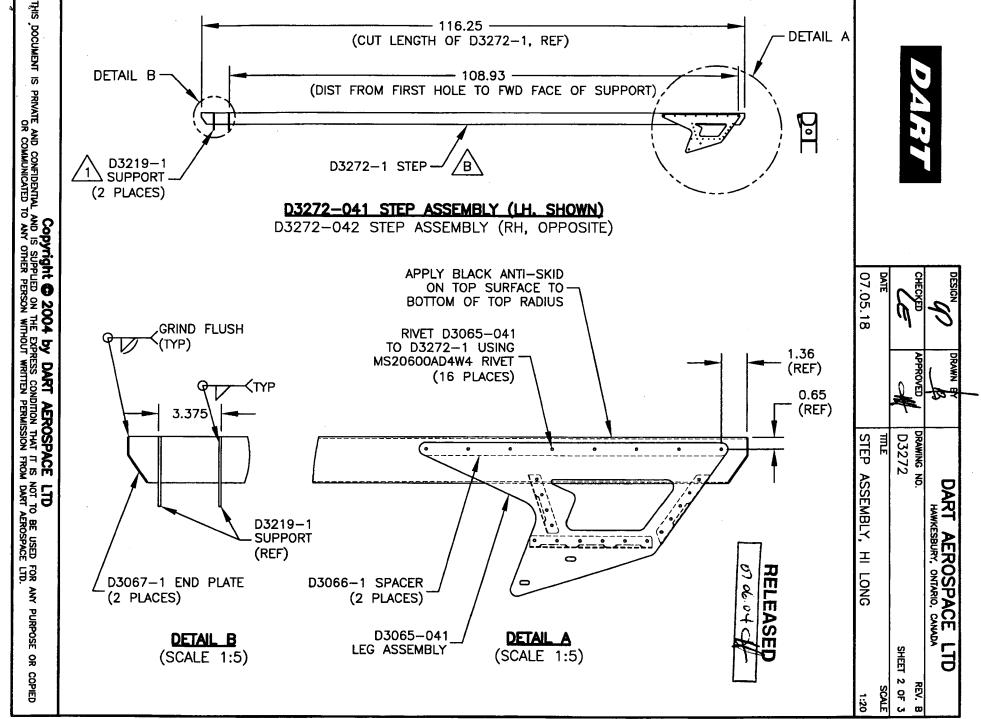
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W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								1 Tod Wigi	
Part No	•	PAR #:	Fault Cate	gory:	_ NCR: Yes	No <b>DQ</b>	A:	_ Date: _	W
	Re	solution:	Disposition	1:	_ QA: N/C Cld	sed:		Date: _	
NCR:		,	WORK ORDE	R NON-CONFORMA	ANCE (NCR	)			
		Description of NC			ion B	Verific	eation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector
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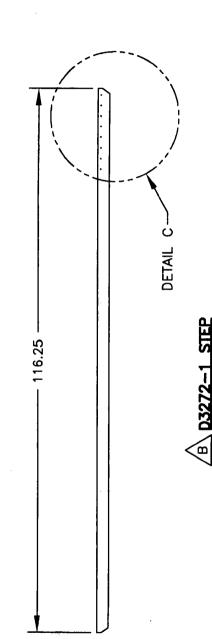


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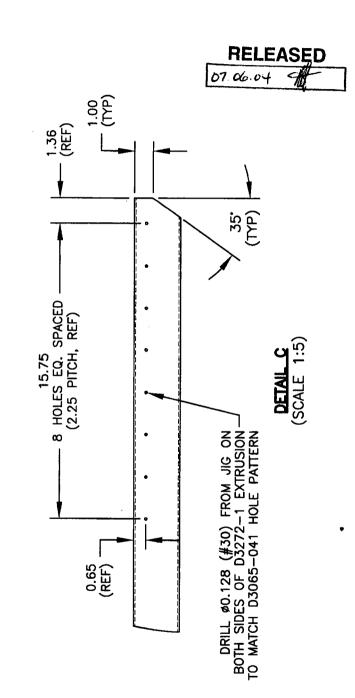
W/O:			W	ORK ORDER CHANG	ES				* 4
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector-
<u> </u>								10.00	
Part No	:	PAR #:	Fault Cat	egory:	_ NCR: Yes	No D	QA:	Date: _	· •••
	R	esolution:	Dispositi	on:	_ QA: N/C (	Closed: _		Date: _	
NCR:	-		WORK OR	DER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section			ification	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat		ection C	Chief Eng	QC Inspector
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RT AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DART CHECKED DRAWING NO. REV. B D3272 SHEET 3 OF 3 DATE TITLE SCALE 07.05.18 STEP ASSEMBLY, HI LONG 1:20



(MAKE FROM D2622-120 STEP EXTRUSION)



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NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Approval	Annaval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector		
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# REFERENCE ONLY

#### DART AEROSPACE LTD.

D350-591 Page 23 of 23

Qty	Otv	Qty	Qty	Qty	Qty	Qty	Qty	Part Number	Description
-211	Qty -212	-213	-214	-215	-216	-311	-312	rait Number	Description
X						011	2 012	D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	Х							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		х						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				Х				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
	-			- ^ -	X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						Х	<del> </del>	D350-591-311	Heli-Access-Step TM, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step - High Skid, RH
								D330-331-312	Tien-Access-Step , Long Step - High Okid, 1411
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	' 2	D2618	<b>₽BUSHING</b>
4	4	4	4	4	4		·	D2732-030	CUSHION
2	2	1	1	1	1	2	; 2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4						-	D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1 1	D3278-041	SUPPORT ASSEMBLY
							-	AND 05A	POLT.
2	2	2	2	2	2	2	1 2	AN3-35A	BOLT
10	10	2	2	2	2		<del> </del>	AN4-11A *	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
			<u> </u>	<u> </u>		2	1 2	AN5-36A ′	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	1 16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	- 2	MS21042L3	NUT
10	10	6	6	6	6	8	1 8	MS21042L4	NUT
						2	1 2	MS21042L5	NUT
		I	1			1	1	*DSI 9410-011 1	STEP MODIFICATION KIT

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.